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2004 / 00154

Seifikaat

PATENTKANTOOR

DEPARTMENT VAN HANDEL
NYWERHEID



Certificate

PATENT OFFICE

DEPARTMENT OF TRADE
AND INDUSTRY

Hiermee word gesetfiseer dat
This is to certify that

2004 / 00154

The attached documents are true copies of the Form P2, P1, P6 and a Provisional Specification of a South African Patent application No. 2004/09654

In the name of : JAN PETRUS HUMAN

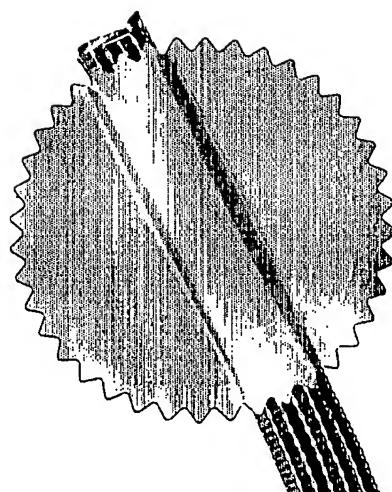
Filed on the : 12th December 2003

Entitled : TAMPER EVIDENT CAP

Getekken te in die Republiek van Suid-Afrika, hierdie
PRETORIA in the Republic of South Africa, this 20th day van
Signed at DECEMBER 2006
day of

A handwritten signature in black ink, appearing to read "D. J. G. VAN DER HORST", is written over a decorative flourish.

Registrateur van Patente
Registrar of Patents



REPUBLIC OF SOUTH AFRICA

REGISTER OF PATENTS

OFFICIAL APPLICATION NO.		LODGING DATE: PROVISIONAL		ACCEPTANCE DATE	
22	01	22	2003-12-12		
INTERNATIONAL CLASSIFICATION		LODGING DATE: COMPLETE		GRANT DATE	
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FULL NAME(S) OF APPLICANT(S) / PATENTEE(S)					
71	JAN PETRUS HUMAN				
APPLICANTS SUBSTITUTED		DATE REGISTERED			
71					
ASSIGNEE(S)		DATE REGISTERED			
71					
FULL NAME(S) OF INVENTOR(S)					
72	JAN PETRUS HUMAN				
PRIORITY CLAIMED		COUNTRY		NUMBER	
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32 —					
TITLE OF INVENTION					
54	TAMPER EVIDENT CAP				
ADDRESS(ES) OF APPLICANT(S) / PATENTEE(S)					
24 ALBERIA STREET, SOMERSET WEST 7130, REPUBLIC OF SOUTH AFRICA					
ADDRESS FOR SERVICE		Brian Bacon & Associates 2 nd Floor Mariendahl House Norwich on Main Newlands 7700 Cape Town Western Cape			BB REF 10417
74					
PATENT OF ADDITION TO NO.		DATE OF ANY CHANGE			
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FRESH APPLICATION BASED ON		DATE OF ANY CHANGE			

REPUBLIC OF SOUTH AFRICA

PATENTS ACT, 1978

APPLICATION FOR A PATENT AND ACKNOWLEDGMENT OF RECEIPT

(Section 30(1) Regulation 22)

THE GRANT OF A PATENT IS HEREBY REQUESTED BY THE UNDERMENTIONED APPLICANT
ON THE BASIS OF THE PRESENT APPLICATION FILED IN DUPLICATE

21 01 OFFICIAL APPLICATION NO . . 2003 / 9654

BB REF: 10417



71 FULL NAME(S) OF APPLICANT(S)

JAN PETRUS HUMAN

ADDRESS(ES) OF APPLICANT(S)

24 ALBERIA STREET, SOMERSET WEST 7130, REPUBLIC OF SOUTH AFRICA

54 TITLE OF INVENTION

TAMPER EVIDENT CAP

REGISTRAR OF PATENTS DESIGNS,
TRADE MARKS AND COPYRIGHT

THE APPLICANT CLAIMS PRIORITY AS SET OUT ON THE ACCOMPANYING FORM P.2.
(COUNTRY) (DATE) (NO.)

2003 -12- 12

21 01 THE APPLICATION IS FOR A PATENT OF ADDITION TO PATENT APPLICATION NO

REGISTRATEUR VAN PATENTE, MODILLE,
HANDELSMERKE EN OUTLETREG.

21 01 THIS APPLICATION IS A FRESH APPLICATION IN TERMS OF SECTION 37 AND BASED ON APPLICATION NO

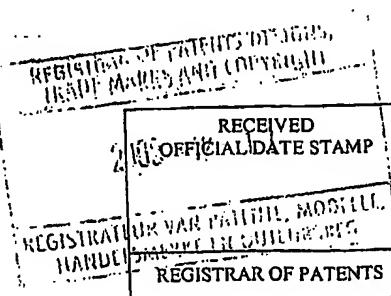
THIS APPLICATION IS ACCCOMPANIED BY:

- 1. A single copy of a provisional or two copies of a complete specification of
- 2. Drawings of 4 sheets
- 3. Publication particulars and abstract (Form P.8 in duplicate).
- 4. A copy of Figure of the drawings (if any) for the abstract.
- 5. An assignment of invention
- 6. Certified priority document(s). (State number)
- 7. Translation of the priority document(s)
- 8. An assignment of priority rights
- 9. A copy of Form P.2 and the specification of RSA Patent Application No
- 10. Form P.2 in duplicate
- 11. A declaration and power of attorney on Form P.3
- 12. Request for ante-dating on Form P.4
- 13. Request for classification on Form P.9
- 14.

74 ADDRESS FOR SERVICE: Brian Bacon & Associates
2nd Floor Mariendahl House
Norwich on Main
Newlands 7700
Cape Town Western Cape

DATED THIS 11th DAY OF December 2003

BRIAN BACON & ASSOCIATES
APPLICANTS PATENT ATTORNEYS
The duplicate will be returned to the applicant's address for service as
soon as possible but is not valid unless endorsed with official stamp



BRIAN BACON & ASSOCIATES
PATENT ATTORNEYS
CAPE TOWN

REPUBLIC OF SOUTH AFRICA
Patents Act, 1978

PROVISIONAL SPECIFICATION
(Section 30 (1) – Regulation 27)

21	01	OFFICIAL APPLICATION NO
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22	LODGING DATE
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2003-12-12

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71	FULL NAME(S) OF APPLICANT(S)
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JAN PETRUS HUMAN

72	FULL NAME(S) OF INVENTOR(S)
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JAN PETRUS HUMAN

54	TITLE OF INVENTION
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TAMPER EVIDENT CAP

FIELD OF THE INVENTION

THIS INVENTION relates to tamper evident closures for containers such as bottles.

BACKGROUND TO THE INVENTION

5 The most commonly used type of tamper evident threaded closure has a series of protrusions which project inwardly from a skirt and interlock with a bead of the container. The protrusions are on a band which forms part of the skirt and which is joined along a line of weakening to the remainder of the skirt. The band itself has a transverse line of weakening extending across it. It is intended that any
10 attempt to remove the cap causes the band to break along its transverse line of weakening. However, it is possible with care to remove such a closure without damaging it, and then screw it back onto the bottle again without damaging it. It consequently does not reveal tampering.

The present invention provides an improved tamper evident closure.

15 BRIEF DESCRIPTION OF THE INVENTION

According to one aspect of the present invention there is provided a method of manufacturing a cap, the method comprising moulding the cap with a skirt which is subdivided by a circumferentially extending line of weakening into a main part and a band, at least the band being of heat shrinkable material.

The method of manufacturing can comprise moulding the cap and subsequently expanding the moulded band thereby to increase its diameter.

The band can be expanded mechanically by means of movable components of the mould, or can be subjected to air pressure which expands the band.

According to another aspect of the present invention there is provided a cap which comprises a transverse end wall and a cylindrical skirt, an end portion of the skirt being in the form of a band which is connected to the skirt along a line of weakening, the band being of heat shrinkable material.

10 According to a further aspect of the present invention there is provided a method of closing a container which comprises fitting a cap as defined above onto the container, and subjecting the band to heating to shrink it onto the container.

BRIEF DESCRIPTION OF THE DRAWINGS

15 For a better understanding of the present invention, and to show how the same may be carried into effect, reference will now be made, by way of example, to the accompanying drawings in which:-

Figure 1 is a section through a cap at an intermediate state in the moulding procedure;

Figure 2 is a similar section showing the cap at a later stage in the moulding

-4-

procedure;

Figure 3 is a pictorial view showing the cap being presented to a bottle for fitting;

Figure 4 is a pictorial view showing the cap on the bottle;

Figure 5 is a section, to a larger scale, showing the cap and bottle of Figure 4;

Figure 6 is a view similar to that of Figure 4 and showing the cap after heat treatment; and

Figure 7 is a section similar to that of Figure 5 and showing the cap after heat treatment.

10

DETAILED DESCRIPTION OF THE DRAWINGS

The cap 10 comprises a transverse end wall 14 and a skirt 16. The skirt has internal threading at 18 which matches external threading of the neck N (see Figures 5 and 7) of the bottle B.

15 The free end portion of the skirt 16 is in the form of a band 24. The band is joined to the remainder of the skirt by a series of circumferentially spaced bridges 26. The effect of this is to provide a circumferentially extending line of perforations 22 which alternate with the bridges 26. The line of perforations 22 is interrupted by a non-perforated zone 30 at which the band 24 is joined to the remainder of the skirt 16. The non-perforated zone 30 constitutes a bridge which is 20 wider than the bridges 26.

The band 24 has a line of weakening 36 which extends from the free

edge thereof to the line of perforations 22. The line of weakening 36 can comprise a series of perforations or a line where the band 24 is of reduced thickness.

As will clearly be seen from Figures 5 and 7, the band 24 is thinner than the remainder of the skirt 16, and there is an internal step at 40 where the
5 change in thickness occurs.

The cap is moulded with its band 24 tapering inwardly as shown in Figure 1. Before the cap is removed from the mould the band 24 is stretched so that it takes on the cylindrical configuration shown in Figure 2. This can be achieved either mechanically by means of parts of the mould which expand forcing the still
10 soft band 24 outwardly or by applying air pressure. This latter method is a technique known as stretch blow moulding.

PET is the preferred material for the cap but any other shrinkable plastics material can be used.

If reference is now made to Figures 4 and 5, it will be seen that the cap
15 10 has been screwed onto the bottle B until the free edge of the band 38 is close to the flange F of the bottle. Movement of the cap 10 is limited by engagement between the bead Q and the step 40 where the main part of the skirt 16 of the cap merges with the band 24. Once the cap has been screwed onto the bottle B as
20 shown in Figures 4 and 5, the capped bottle moves into a heat shrink tunnel. The main purpose of heating the bottle is to shrink the bottler's synthetic plastics material

sleeve shaped label around the body of the bottle. The effect of the heat on the thin band 24 is to cause it to shrink back to the condition in which it was moulded (see Figure 1) which results in it tightly gripping the bottle between the bead and the flange (Figure 7).

The cap is removed from the bottle by twisting it. The band 24, because it is a tight fit around the neck of the bottle, resists turning and the result is that the cap breaks along the line of weakening 36. The band 24 also breaks along the line of perforations 22 and either separates from the remainder of the cap entirely or remains attached to it by way of the zone 30 across which the line of perforations 22 does not extend. The fact that the cap has previously been removed from the bottle is evident because the band is either missing completely or is only attached to the remainder of the cap at the zone 30 but broken along its axially extending line of weakening.

Dated this 11th day of December 2003

**Brian Bacon & Associates
Applicant's Patent Attorney**

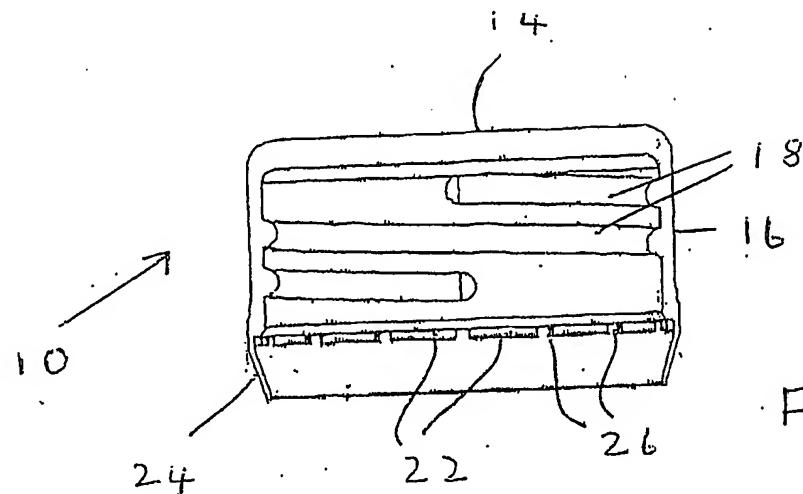


Fig. 1

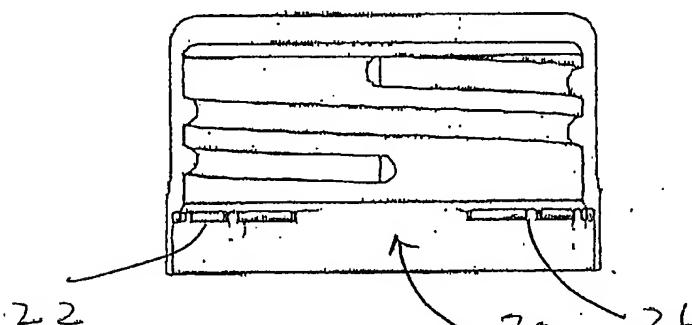


Fig. 2

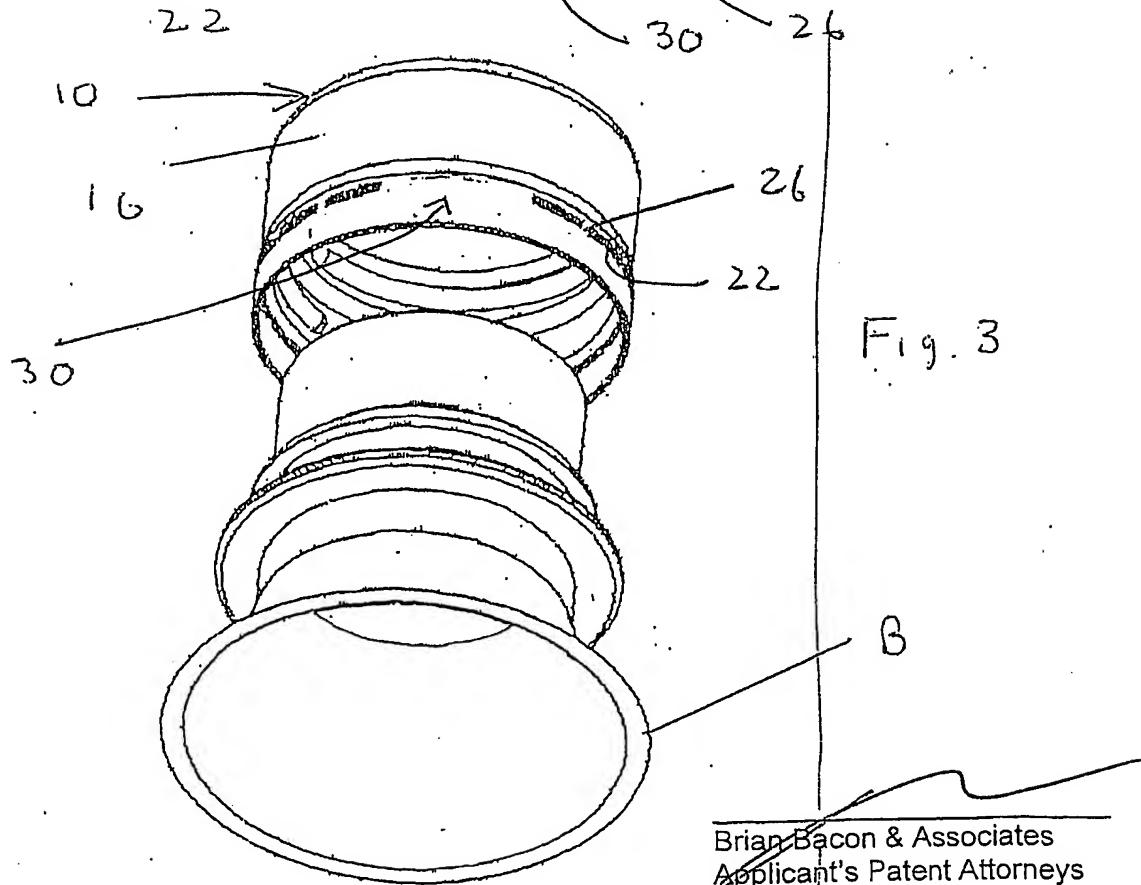
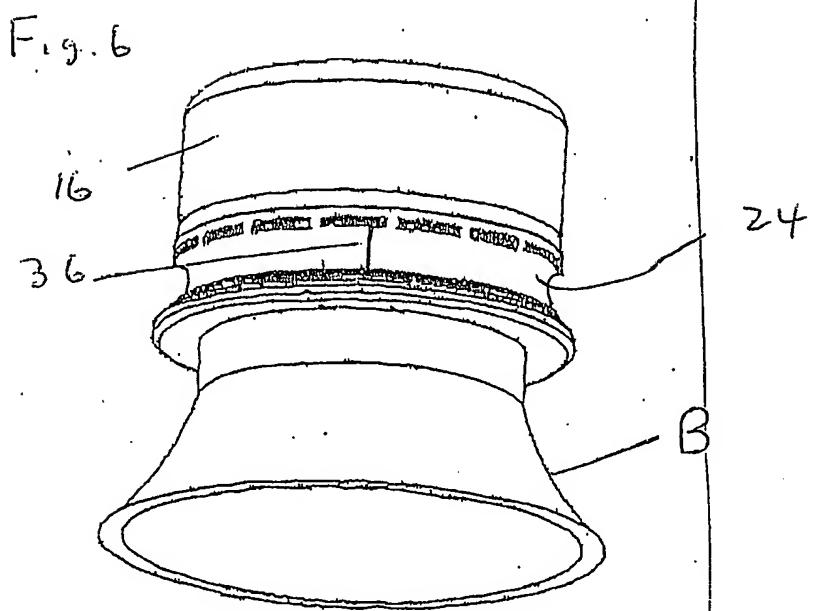
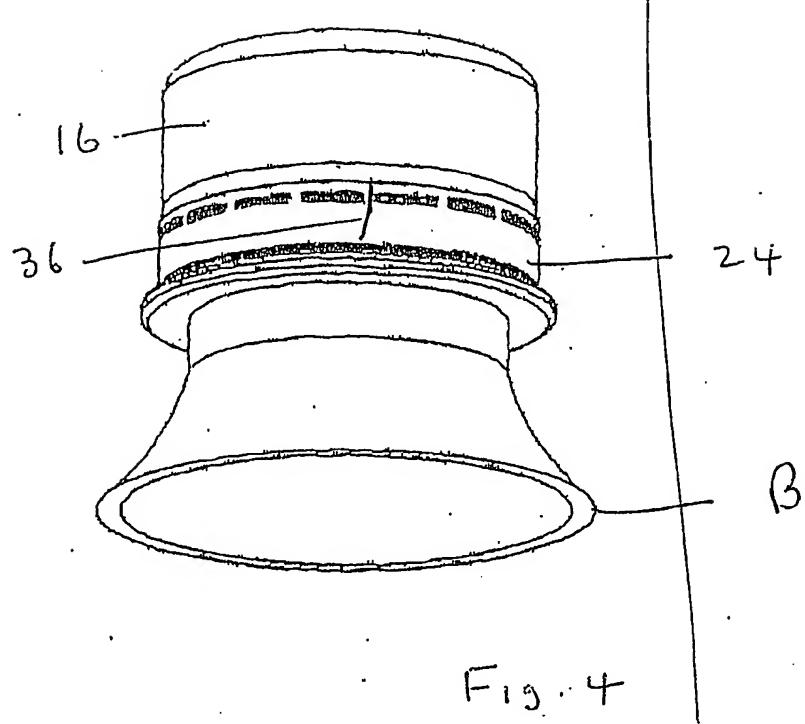


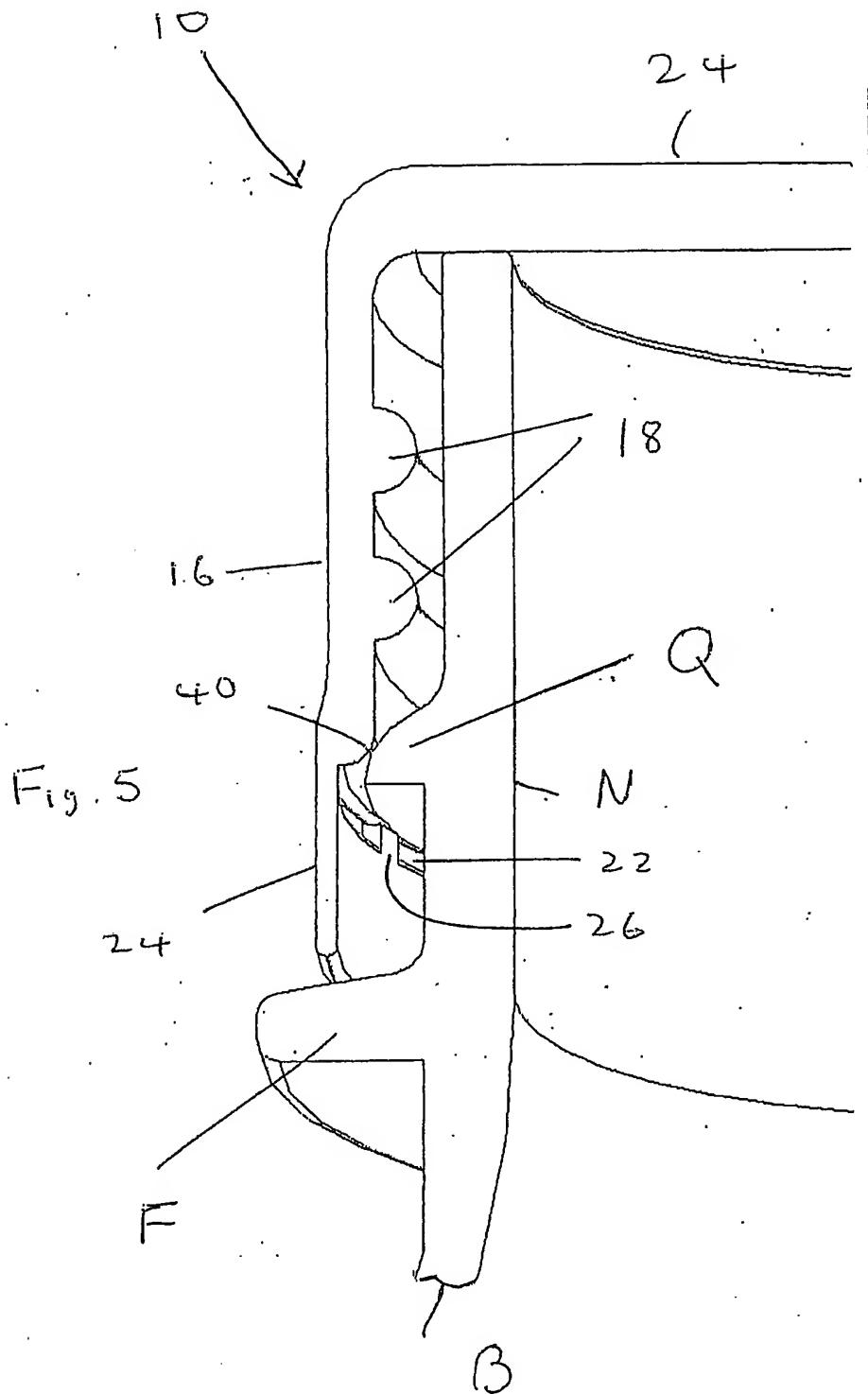
Fig. 3



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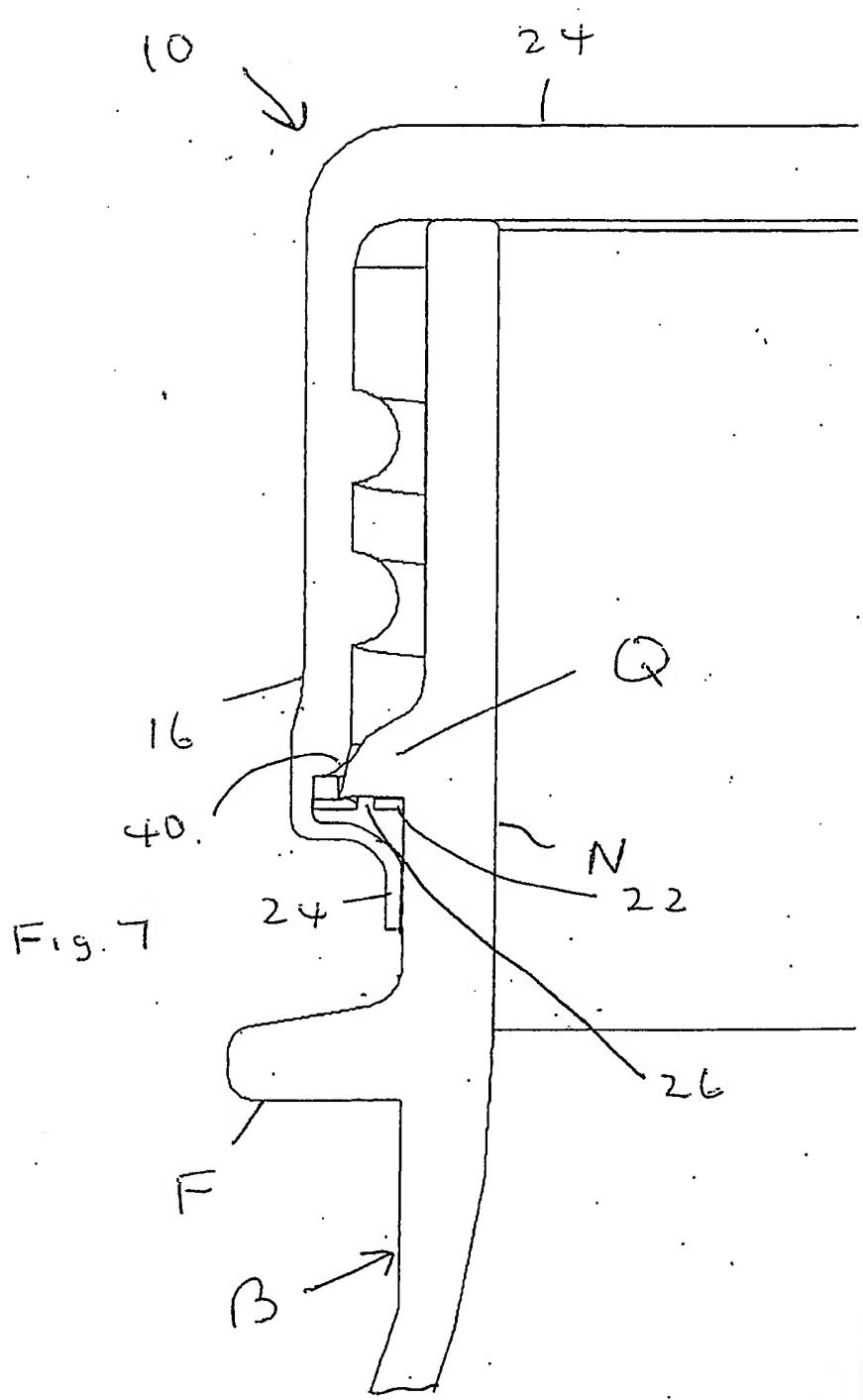


~~Brian Bacon & Associates
Applicant's Patent Attorneys~~

2003/9651

Jan Petrus Human

4 Sheets
Sheet No.4




Brian Bacon & Associates
Applicant's Patent Attorneys